Work Order ID 62672

Thursday, October 07, 2010 8:08:27 AM

Item ID: D2324-5 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Strap

Start Date: 10/6/2010 **Start Qty:** 12.00 **Cust Item ID:**

Required Date: 10/15/2010 **Req'd Qty:** 12.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 10-10-07 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D2324	Revision Nbr: Rev C								
100 Waterjet	FLOW WATER JET	0.00				B10-10-8			
FLOW CNC Waterjet 304.063	**Memo** 1-Cut as per Dwg D2324 ☐Dwg Rev: C ☐Prog Rev: C ☐2-Deburr if necessary	0.00				17			
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00				B10-10-8			
	Memo	0.00							
120 QC Quality Control	QC8- Inspect parts - second check	0.00				17			
	Memo	0.00							

S 10/10/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 62672

Thursday, October 07, 2010 8:08:27 AM

Item ID: D2324-5 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Strap

Start Date: 10/6/2010 **Start Qty:** 12.00 **Cust Item ID:**

Required Date: 10/15/2010 **Req'd Qty:** 12.00 **Customer:**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: 011	0.00							
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/10/12 (17)

10/10/12 MF

10-10-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 8:08:31 AM

Work Order ID: 62672

Parent Item: D2324-5

Parent Item Name: Strap

Start Date: 10/6/2010 **Required Date:** 10/15/2010

Start Qty: 12.00 **Required Qty:** 12.00

Comments: IPP E□03.02.28□Reformat; Incorporated D2324-3 & D2324-5□KJ/RF□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	70.6100	0.0184	0.2208			

304/316 Sheet .063

BR 10-10-7

Location	Loc Qty	Loc Code
MAT	64.77	
111323	0	
115688	64.77	
MAT20	5.84	
115440	5.84	

115688

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	4277
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.38	+/-0.030	.38	✓		R.G.	
Ø0.257	+0.006/-0.001	.259	✓		V HB02	
Ø0.191	+0.005/-0.001	.192	✓		V	
0.750	+/-0.010	.757	✓		V	
0.375	+/-0.010	.377	✓		V	
1.875	+/-0.010	1.877	✓		V	
3.000	+/-0.010	3.001	✓		V	
3.375	+/-0.010	3.378	✓		V	

Measured by:	JB
Date:	10-10-7

Audited by:	S
Date:	10/10/08

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

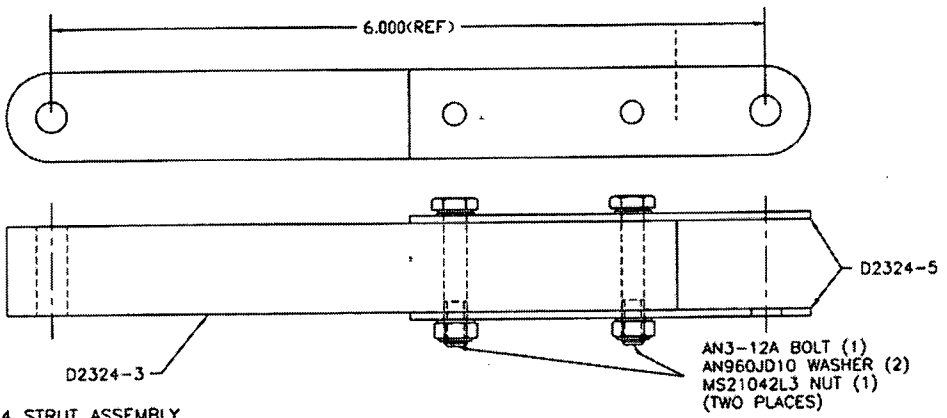
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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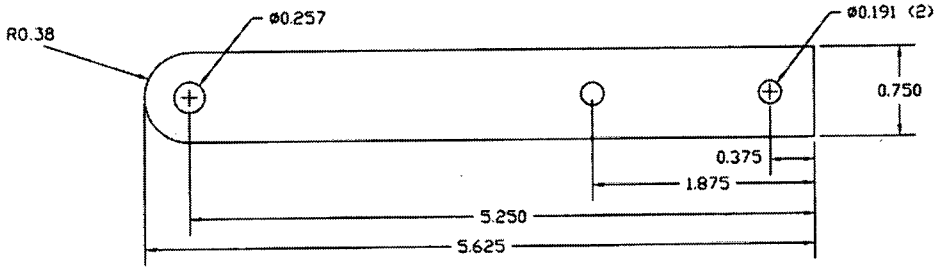
DESIGN: B WILLIAMS	DRAWN BY: PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED:	APPROVED:	DRAWING NO.: D2324	REV. C SHEET 1 OF 1
DATE: 04.12.14		TITLE: STRUT	SCALE

A	94.11.08	NEW ISSUE
B	96.05.07	UPDATE MATERIALS
C	04.12.14	UPDATE NOTES

RELEASED
04.12.16

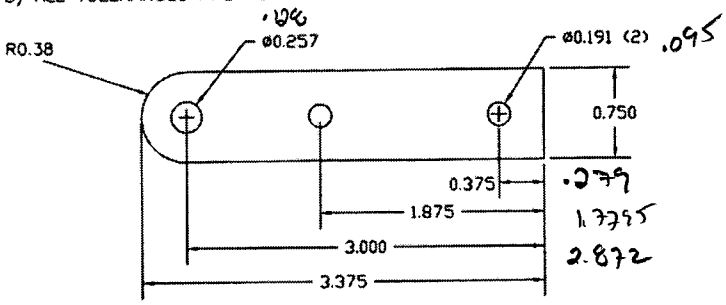


D2324 STRUT ASSEMBLY
1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62672
10-10-07

D2324-3
1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.005 TO 0.015
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.005 TO 0.015
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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